

Work Order ID 87091

87091

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Item ID: D412-742-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Skidtube Installation

Start Date: 8/06/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/06/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: P Date: 12-07-11 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-742	E

100	DOCUMENT CONTROL	0.00	2 Labels BLANC	DAS 16 8-03	12/08/29				MLJ 12/08/29
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-742-013		CHG007	JB					

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							12/08/28 JB
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

687072

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87091

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Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Float Skidtube Installation
 Start Date: 8/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013								
	Location: 63								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLT 12/08/30
 MLT 12/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM
 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP Rev: F: add AN4C7A DD
 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per DSI9517 REV.B DD verified
 by: EC IPP rev: H 12.01.12 PER IIN REV.E DD VERF: IPP Rev: I add AN4C7A
 DD 12.03.14 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A Bolt		Purchased	No			110	Each	128.0000	4	122491	4	12/08/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST361		128							
				118451		6							
				119798		2							
				121009		22							
				121585		2							
				122012		46							
				122204		50							
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1	1	12/08/27	
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	15.0000	1	84989	1	12/08/28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		1							
				11644		1							
				ST425		-13							
				ST432		14							
				85607		8							
				85883		6							
				ST433		13							

W/O:		WORK ORDER CHANGES					
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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

D2572 Manufactured No

110 Each 7.0000

1 84990 1 8 JB

Saddle, Fwd In 205

Location	Loc Qty	Loc Code
ST432	7	
71107	2	
85882	5	

D2573 Manufactured No

110 Each 3.0000

1 85609 1 8 JB

Saddle, Aft Out 205

Location	Loc Qty	Loc Code
ST423	-12	
79424	0	
ST433	3	
83669	3	
ST434	12	

D2574 Manufactured No

110 Each 3.0000

1 85610 1 8 JB

Saddle, Aft In 205

Location	Loc Qty	Loc Code
ST433	3	
83671	3	

D2876 Manufactured No

110 Each 94.0000

2 2 8 JB

Saddle Spacer

Location	Loc Qty	Loc Code
ST020	94	
83323	40	
83890	54	

83323

D2877 Manufactured No

110 Each 104.0000

2 2 8 JB 12/08/28

Saddle Spacer

Location	Loc Qty	Loc Code
ST020	104	
83324	3	
83891	61	
86442	40	

86442

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

D3403-1
Bushing

Manufactured No

110 Each 65.0000 8 8 *23 88*

Location	Loc Qty	Loc Code
ST041	15	
70696	15	
ST042	50	
80208	7	
80219	4	
85661	39	

D3403-5
Bushing

Manufactured No

110 Each 45.0000 8 8 *85847 23 88*

Location	Loc Qty	Loc Code
ST042	45	
85664	45	

D2747
Set Screw

Manufactured No

110 Each 296.0000 4 4 *23 88*

Location	Loc Qty	Loc Code
ST017	296	
79520	5	
81877	91	
86439	200	

D3533-1
Set Screw

Manufactured No

110 Each 68.0000 2 2 *87348 23 88 12/08/28*

Location	Loc Qty	Loc Code
ST053	68	
80326	2	
83892	66	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

AN4C6A Purchased No 110 Each 399.0000 16 16 ✓ JB

Bolt

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	395	
116704	2	
120423	1	
121657	392	

AN4C53A Purchased No 110 Each 105.0000 4 4 ✓ JB

Bolt

Location	Loc Qty	Loc Code
ST361	105	
122193	99	
122194	6	

AN4C52A Purchased No 110 Each 8.0000 4 4 ✓ JB

BOLT

Location	Loc Qty	Loc Code
ST361	8	
117688	6	
120364	2	

AN6C12A Purchased No 110 Each 48.0000 8 8 ✓ JB 12/08/28

BOLT

Location	Loc Qty	Loc Code
ST341	48	
121541	7	
122204	41	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

D3672-3	Manufactured	No	110	Each	1,275.0000	32	32	JB	82
Phenolic Washer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST060	1275					
			84361	275					
			84432	500			84432		
			86517	500					
AN960C416L	Purchased	No	110	Each	0.0000	32	32	JB	82
WASHER							121255		
D3672-9	Manufactured	No	110	Each	308.0000	8	8	JB	82
Phenolic Washer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST060	308					
			81763	308			81763		
NAS1149C0632R	Purchased	No	110	Each	183.0000	8	8	JB	82
WASHER									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST297	183					
			119736	2					
			120308	1					
			121825	180			121825		
D3672-11	Manufactured	No	110	Each	203.0000	8	8	JB	12/08/28
Phenolic Washer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST060	203					
			77483	203			77483		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No 110 Each 1,766.0000 29

Nut

122452 JB

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	726	
119546	4	
121162	282	
121652	440	
ST318	1000	
122141	1000	

D3403-3

Bushing

Manufactured No 110 Each 52.0000 8

Location	Loc Qty	Loc Code
ST042	52	
85662	52	

8 JB

D3405-041

Lug Assembly

Manufactured No 110 Each 13.0000 1

Location	Loc Qty	Loc Code
ST478	13	
62227	2	
77000	2	
83370	3	
83896	6	

1 86762 JB

D3405-043

Lug Assembly

Manufactured No 110 Each 8.0000 1

Location	Loc Qty	Loc Code
ST478	8	
82038	1	
83897	7	

1 86757 JB 12/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

AN4C7A	Purchased	No		110	Each	123.0000	4	✓ JB [8]
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST356	123				
			109147	123			109147	
D3407-041	Manufactured	No		110	Each	1.0000	1	1 ✓ JB [8]
Tow Ring								88213
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST463	1				
			82068	1				
D3417-3	Manufactured	No		110	Each	21.0000	2	2 ✓ JB [8]
Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	9				
			33519	9				
			ST042	12				
			80225	12			80225	
D3456-1	Manufactured	No		110	Each	214.0000	1	1 ✓ JB 12/08/28
Washer								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	7				
			25701	7				
			ST044	207				
			80252	1				
			81876	14				
			83584	92				
			85223	100			85223	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

AN3C37A Purchased No 110 Each 154.0000 1 1 ✓ JB 8

BOLT

Location	Loc Qty	Loc Code
ST324	50	
122204	50	
ST354	104	
116874	11	
117010	2	
120422	3	
121068	36	
121584	2	
121585	50	

121585

AN3C40A Purchased No 110 Each 20.0000 1 1 ✓ JB 8

BOLT

Location	Loc Qty	Loc Code
ST354	20	
114442	20	

114442

AN3C41A Purchased No 110 Each 211.0000 1 1 ✓ JB 12/08/28

BOLT

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	207	
121013	26	
121313	80	
121689	1	
122241	100	

122241

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 87091

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12

Required Date: 8/06/12

Start Qty: 1.00

Required Qty: 1.00

AN3C42A Purchased No 110 Each 69.0000 1 1 ✓ JB

BOLT

Location	Loc Qty	Loc Code
ST354	69	
106176	1	
120464	1	
121103	17	121103
122241	50	

AN3C43A

Purchased

No

110 Each 61.0000

4 4 ✓ JB

BOLT

Location	Loc Qty	Loc Code
ST354	61	
114455	2	
119673	1	
120465	58	120465

AN3C46A

Purchased

No

110 Each 51.0000

5 5 ✓ JB

BOLT

Location	Loc Qty	Loc Code
ST355	51	
120447	3	
122204	48	122204

AN960C10L

NAS1149C0332R

Purchased

No

110 Each 21.0000

26 26 ✓ JB 12/08/28

washer

Location	Loc Qty	Loc Code
ST	21	
107534	21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 87091
 Parent Item: D412-742-013
 Parent Item Name: Float Skidtube Installation

Start Date: 8/06/12 Required Date: 8/06/12
 Start Qty: 1.00 Required Qty: 1.00

MS21043-3 Purchased No
 Nut

110 Each 1,086.0000 13 13

✓ *12/08/28*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST301	1014	
118077	2	
118614	12	
118686	30	
119758	20	
121255	93	
121708	857	<i>121708</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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